

Work Order ID 85200

85200

Page 1

June-04-12 1:34:36 PM

Item ID: D3325-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 04/06/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 18/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/06/04 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3325	Rev B

100		0.00
100	Large Fab	
Large Fab	Memo	0.00
Large Fab	1-Cut tubes as per Dwg D3325	

Qty	Part Number	Description	Batch
2	D3325-1	End Tube	<u>4122760</u>
3	D3325-3	Interior Tube	<u>4122760</u>
2	D3325-5	Full Length Tube	<u>4122760</u>

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004
 A/R4130 Steel Rod 41100075

4-Deburr as required

1x **DAS**
43
9-89 13-11-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3325-041
Revision ID:
Item Name: Basket Lid Assembly

Accept

N900040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 04/06/2012 Start Qty: 1.00 ***1***
Required Date: 18/06/2012 Req'd Qty: 1.00 ***1***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									DAS
QC	Memo	0.00							9
Quality Control									9-89
120	QC5- Inspect part completeness to step on W/O	0.00							
120									DAS
QC	Memo	0.00							9
Quality Control									9-89
121	Pressure Wash per QSI005 4.3	0.00							
121									
HandFinish	Memo	0.00							
Hand Finishing									

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Revision ID:

Item Name: Basket Lid Assembly

Stop *NS2*

Start Date: 04/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

130

M126829

Powdercoat

Memo

0.00

Powder Coating

1ST COAT:

START TIME: 8:35

OVEN TEMPERATURE: 400°

FINISH TIME: 9:05

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 18-11-11

DAS
34
9-89

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

12 13/11/11

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Stop *NS2*

Start Date: 04/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 18/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location: w/o

0.00

D350-721-041/1385196

150

Packaging

Memo

0.00

Packaging

1x d 10 13/11/11

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/11/12

ME

13-11-11

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

June-04-12 1:34:40 PM

Page 1 12.

Work Order ID: 85200

85200

Parent Item: D3325-041

D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JLM
IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3328-1		Manufactured	No			100	Each	17.0000	2	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3328-1

Basket Hinge

**

B 33871 → 2x

DAS 43 13-11-04
2-09

Location	Loc Qty	Loc Code
WA	10	
84317	10	
WA005	7	
33871	7	

D3349-1		Manufactured	No			100	Each	12.0000	2	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3349-1

Spacer Bushing

**

B 44401 → 2x

DAS 43 13-11-04
2-09

Location	Loc Qty	Loc Code
WA005	12	
44401	12	

D3352-1		Manufactured	No			100	Each	6.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3352-1

Label Plate

**

B 41925

DAS 43 13-11-04
2-09

Location	Loc Qty	Loc Code
WA005	6	
41925	6	

D3367-1		Manufactured	No			100	Each	7.0000	2	2			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3367-1

Mounting Bracket

**

B 86746 → 2x

DAS 43 13-11-04
2-09

Location	Loc Qty	Loc Code
WA005	7	
76500	7	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

June-04-12 1:34:40 PM

Page 2

Work Order ID: 85200

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Parent Item: D3325-041

D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 04/06/2012

Required Date: 18/06/2012

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

240.7376

20.5416

21.62274

M4130NTS0 500W 035

4130 Square tube .500 x .500 x .035w

**

4122760 → 21.62

Location

Loc Qty

Loc Code

MAT034

240.7376

109127

39.5367

109385

15.75

112786

17.6261

119441

8.8248

119506

36.34

119683

122.66

DAS
43
9-89

13-10-31

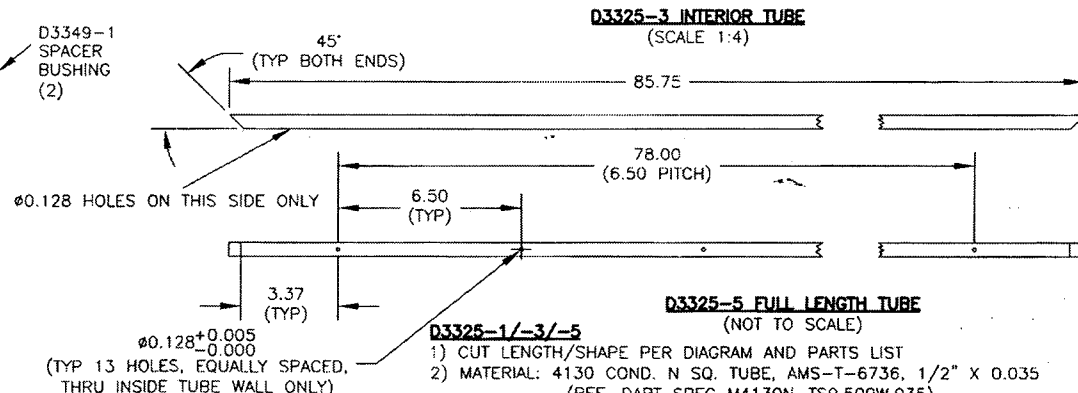
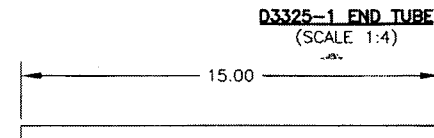
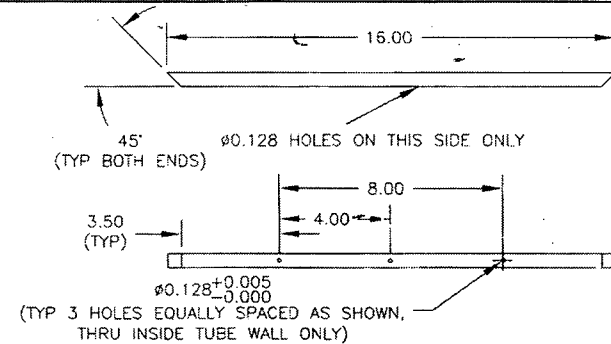
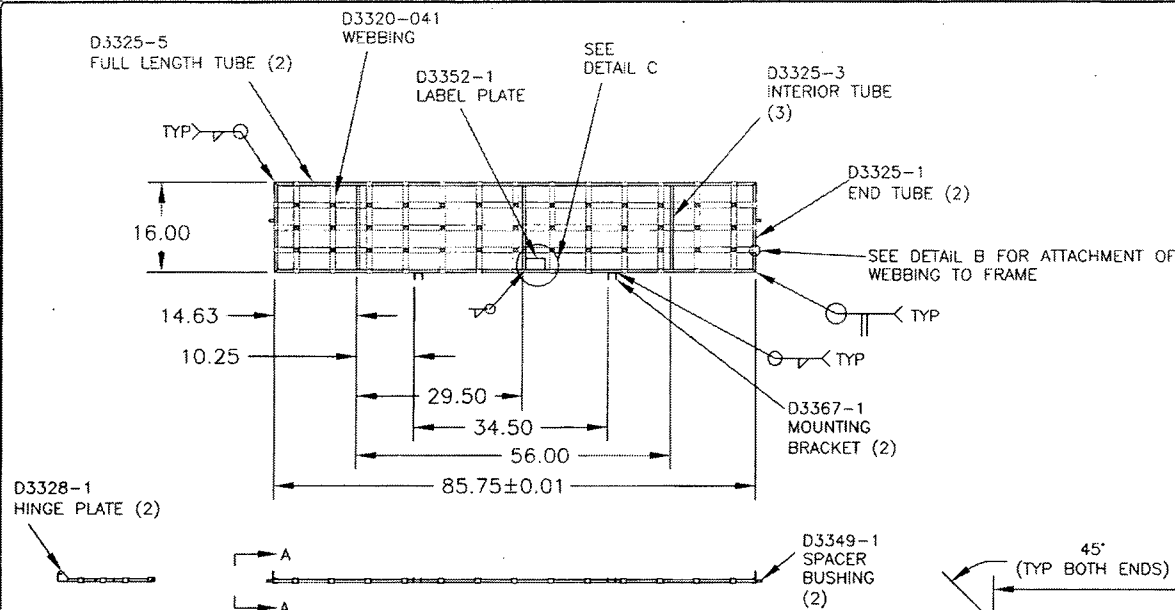
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NOTE: Date & initial all entries



D3325-041 BASKET LID ASSEMBLY

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-041)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PARTS LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description
D2729-1	1	PRODUCT ID LABEL
D3320-041	1	WEBBING
D3325-1	2	END TUBE
D3325-3	3	INTERIOR TUBE
D3325-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20600AD4W3	32	RIVET
AN960J09	32	WASHER

RELEASED
05-04-25

DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 85200 MLJ

12/06/04

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B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3325
DATE	05.04.25	TITLE BASKET LID ASSEMBLY
		REV. B SHEET 1 OF 3 SCALE 1:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

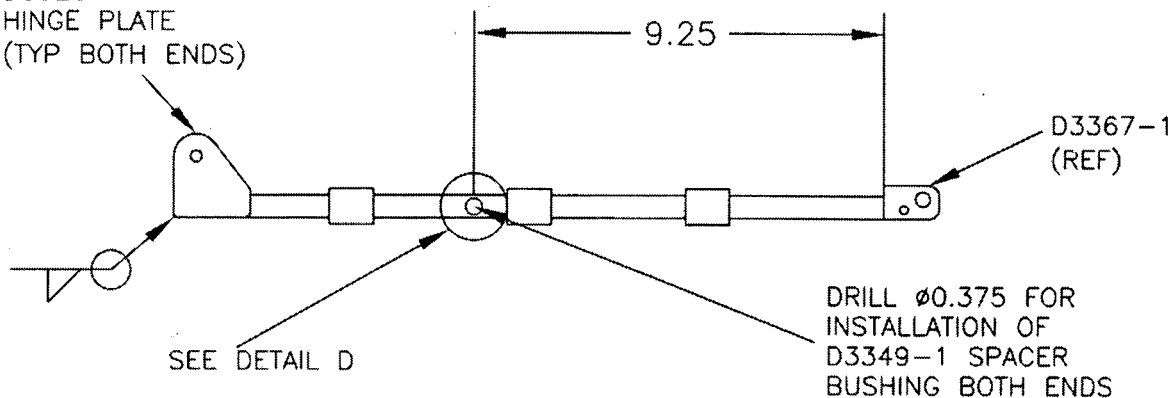
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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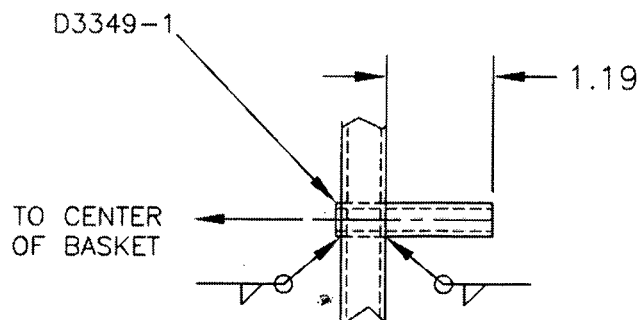


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4

D3328-1
HINGE PLATE
(TYP BOTH ENDS)



VIEW A-A



DETAIL D
(SCALE 1:2)

DEO ATTACHED

RELEASED
05.04.28 [Signature]

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05200

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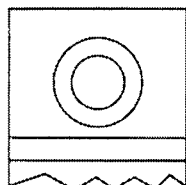
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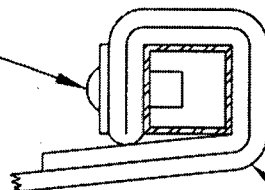
NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4



MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)

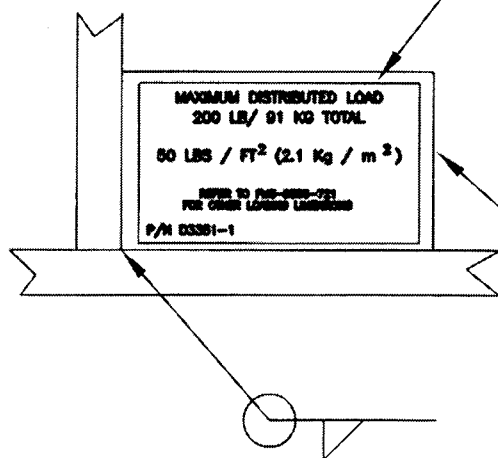


DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-041 WEBBING

RELEASED
05.04.28
DEO ATTACHED

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

OUTBOARD

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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05200

DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>			
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

PART LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description

IS:

MS20600AD4W5	32	RIVET

WAS:

MS20600AD4W3	32	RIVET

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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